



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-041
Job Sheet 177916



Part No: D205-634-041

Job Qty: 1 ea

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/23/18

Job Tracking No:

Due Date: 6/6/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:



Bill of Materials

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S077536



Part: D205-634-041

Job No: 177916

Serial No/Batch: S077536

Revision: H

Inspector:

Exp Date: 06/04/2018

Instructions:

Date: 06/04/18

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/6/18	6/6/18	0.00	0.00	Start Up Skid tubes		MEG
110	CNC Bend Skid tubes	1 pcs	6/6/18	6/6/18	0.00	0.65	CNC Bend Skid tube		MEG DO
120	Skid tubes	1 pcs	6/6/18	6/6/18	0.00	2.89	Skid tubes-2		DO
130	QC	1 pcs	6/6/18	6/6/18	0.00	0.00	QC5		BE
140	Skid tubes	1 pcs	6/6/18	6/6/18	0.00	2.89	Skid tubes-2		BE DO
150	QC	1 pcs	6/6/18	6/6/18	0.00	0.00	QC10		38 DAS
160	QC	1 pcs	6/6/18	6/6/18	0.00	0.00	QC5		8-88 38
170	HandFinish	1 pcs	6/6/18	6/6/18	0.00	1.31	HandFinish1		SA 18-06-06
180	Powdercoat	1 pcs	6/6/18	6/6/18	0.00	0.34	Powdercoat1		BE 18-6-6
190	QC	1 pcs	6/6/18	6/6/18	0.00	0.00	QC3		ME 18-6-6
200	HandFinish	1 pcs	6/6/18	6/6/18	0.00	1.31	HandFinish4		DAS
210	QC	1 pcs	6/6/18	6/6/18	0.00	0.00	QC5		21
220	Packaging	1 pcs	6/6/18	6/6/18	0.00	0.00	Packaging3-1		9-88 JUN 8 2018
225	DC	1 pcs	6/6/18	6/6/18	0.00	0.00	DC		21
230	QC21-FG	1 Ea	6/6/18	6/6/18	0.00	0.00	QC21		9-88 JUN 8 2018

Part Op 110 - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe batch# in Descriptions: aft end of tube

120 - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

140 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

170 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - START TIME: 11:50 OVEN TEMPERATURE: 350° FINISH TIME: 12:20

200 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 1138787 Sikaflex expire date: 18/12 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 1138787 Sikaflex expire date: 18/12

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 1138851

210 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

003705

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	5076456
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	140-Skid tubes	5069014
D4202-1	Spacer	20 Ea (20 ea)	140-Skid tubes	5054571
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-HandFinish	5045668
AN3-5A	Bolt	2 Ea (2 ea)	200-HandFinish	5041106-1
AN3C4A	Bolt	50 Ea (50 ea)	200-HandFinish	5041114
D2594-1	Plug	16 Ea (16 ea)	200-HandFinish	5059021
D2594-3	O-Ring	16 Ea (16 ea)	200-HandFinish	5049972
D2855	Cap	1 Ea (1 ea)	200-HandFinish	FIS1613
D3564-11	Wearplate Aft	1 Ea (1 ea)	200-HandFinish	5045366
D3564-13	Wearpad Fwd	1 Ea (1 ea)	200-HandFinish	5045900
D3564-5	Wearplate Center	1 Ea (1 ea)	200-HandFinish	x 5077530
D3564-9	Wearplate Fwd	1 Ea (1 ea)	200-HandFinish	5054597
NAS1149C0332R	Washer	50 Ea (50 ea)	200-HandFinish	5056443
NAS1149D0332J	Washer	2 Ea (2 ea)	200-HandFinish	5020606-1

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	0	0
140-Skidtubes	D2576-3	1	43	0
	D4202-1	20	413	0
200-HandFinish	ALS7-1032-130	50	2,049	0
	AN3-5A	2	314	0
	AN3C4A	50	2,319	0
	D2594-1	16	504	0
	D2594-3	16	773	0
	D2855	1	95	0
	D3564-11	1	20	0
	D3564-13	1	17	0
	D3564-5	1	14	0
	D3564-9	1	20	0
	NAS1149C0332R	50	7,148	0
	NAS1149D0332J	2	2,291	0

Part Specifications

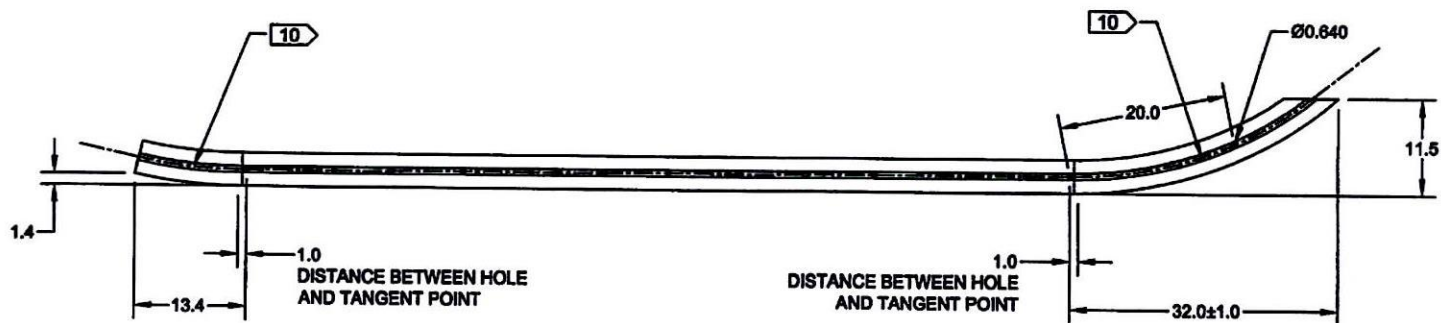
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Plex 5/23/18 10:08 AM dart.white.jesse



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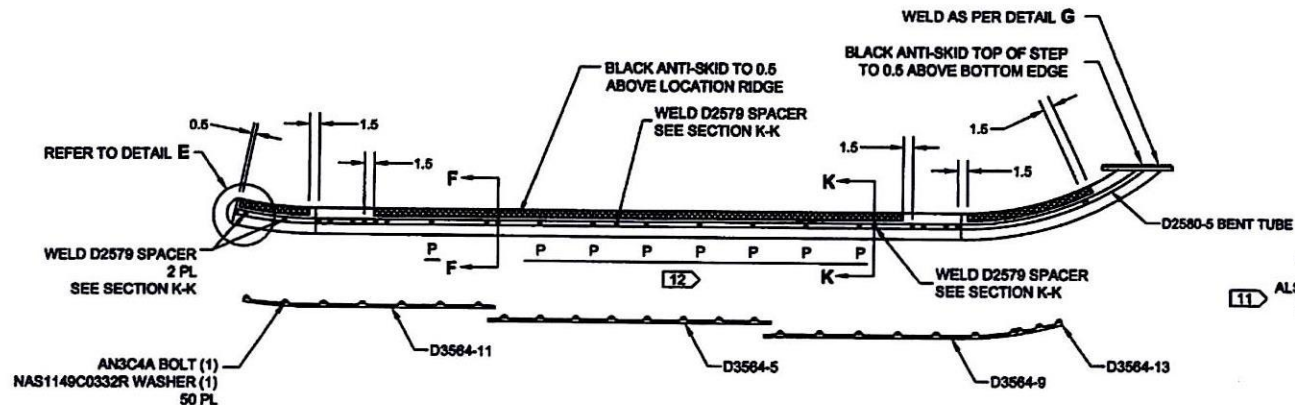
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MFG. APPR.	<i>[Signature]</i>	
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DE APPR.	<i>[Signature]</i>	
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

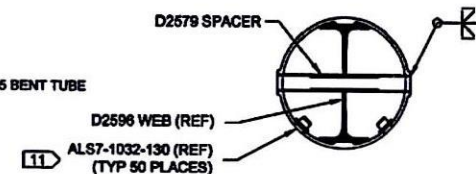
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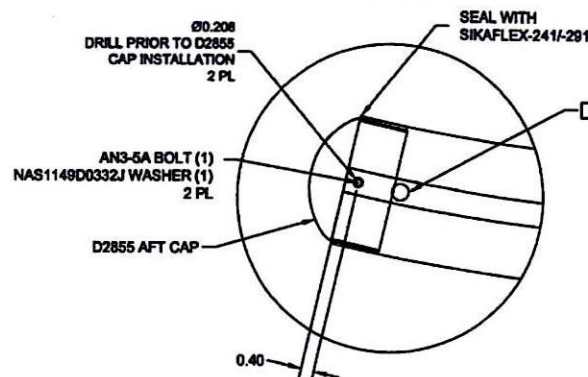
D2580-045 ASSEMBLY DETAIL

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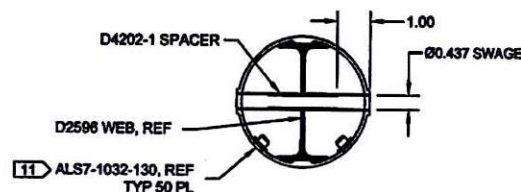


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**

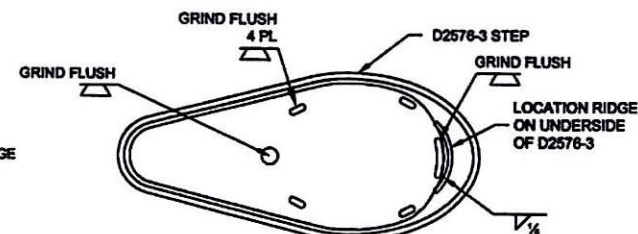


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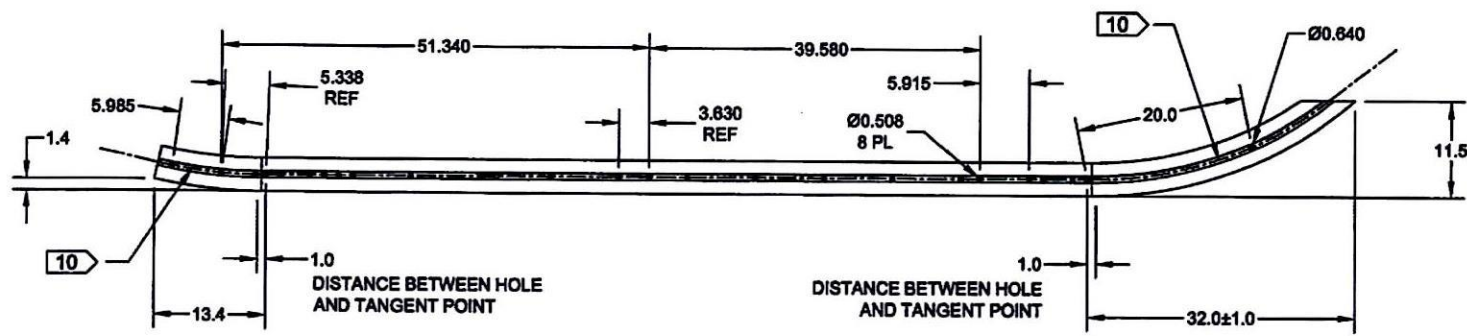
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
SCALE 5X**



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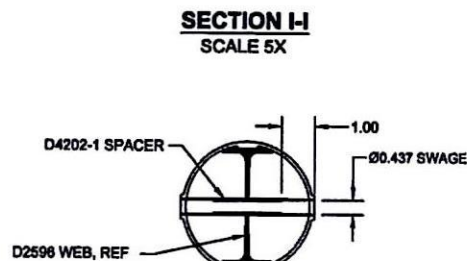
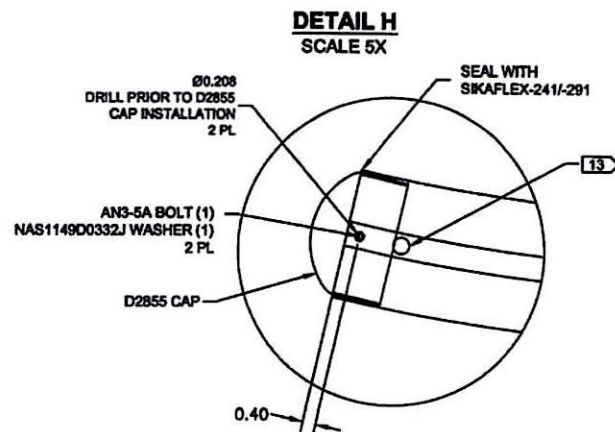
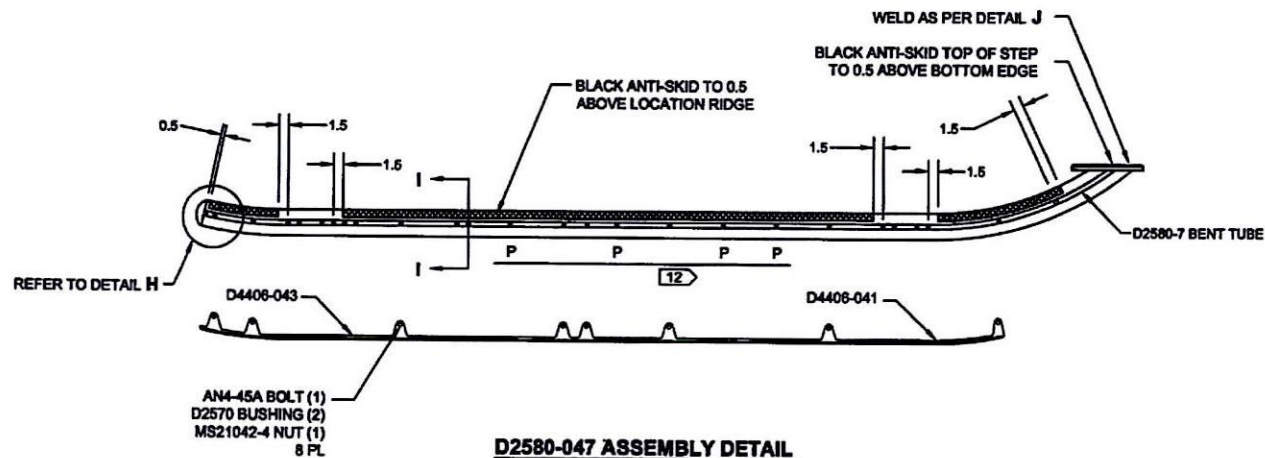
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D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

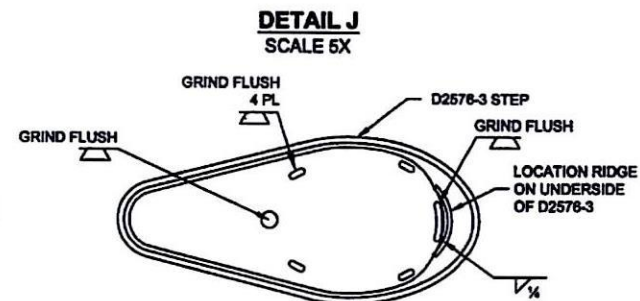
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AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

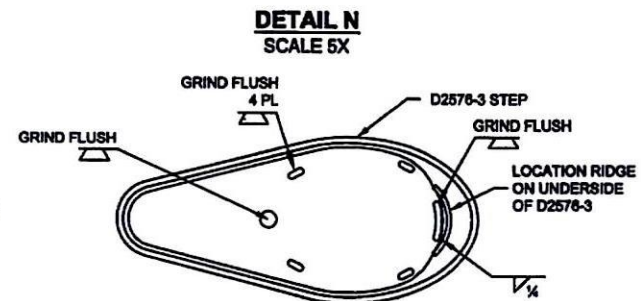
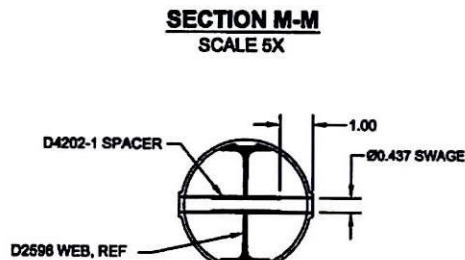
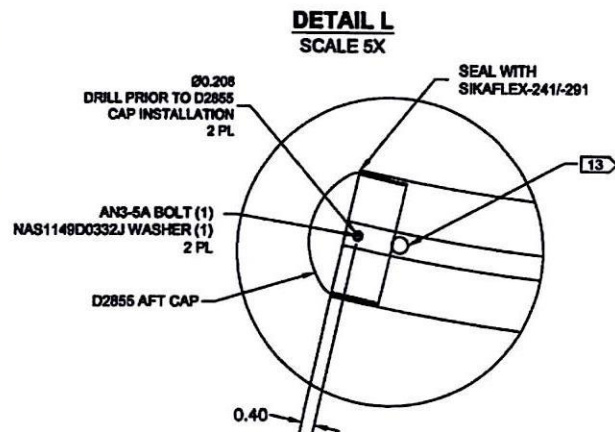
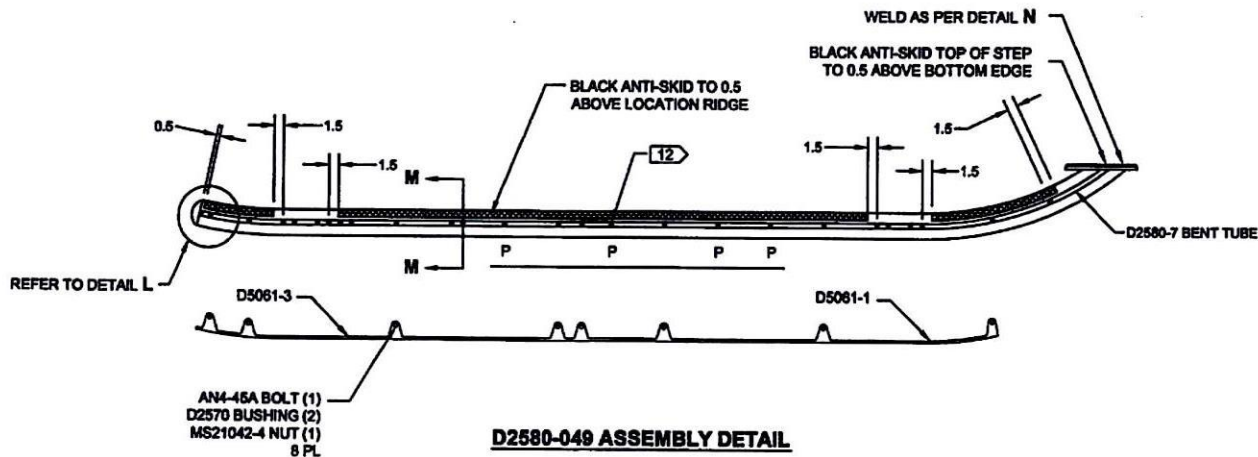
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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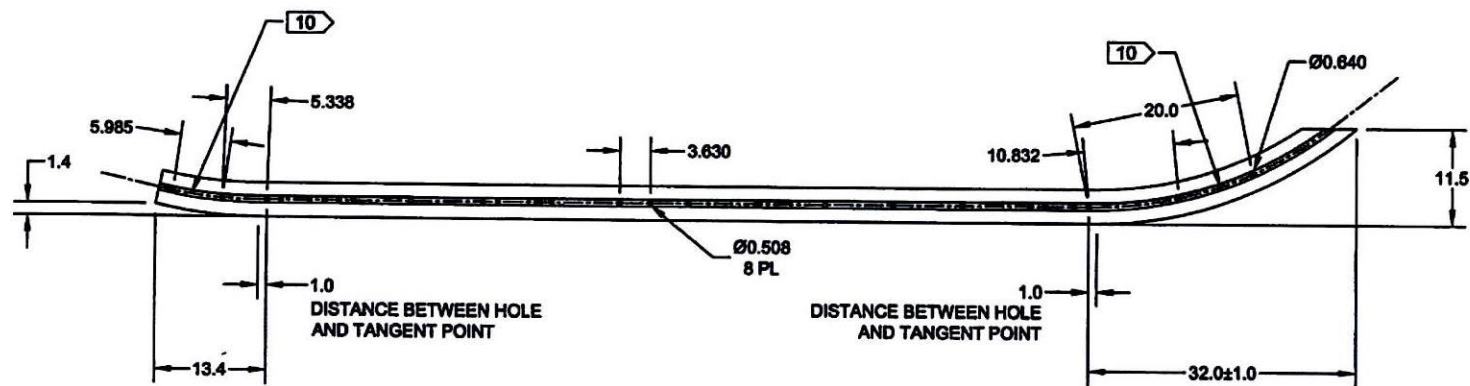


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PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

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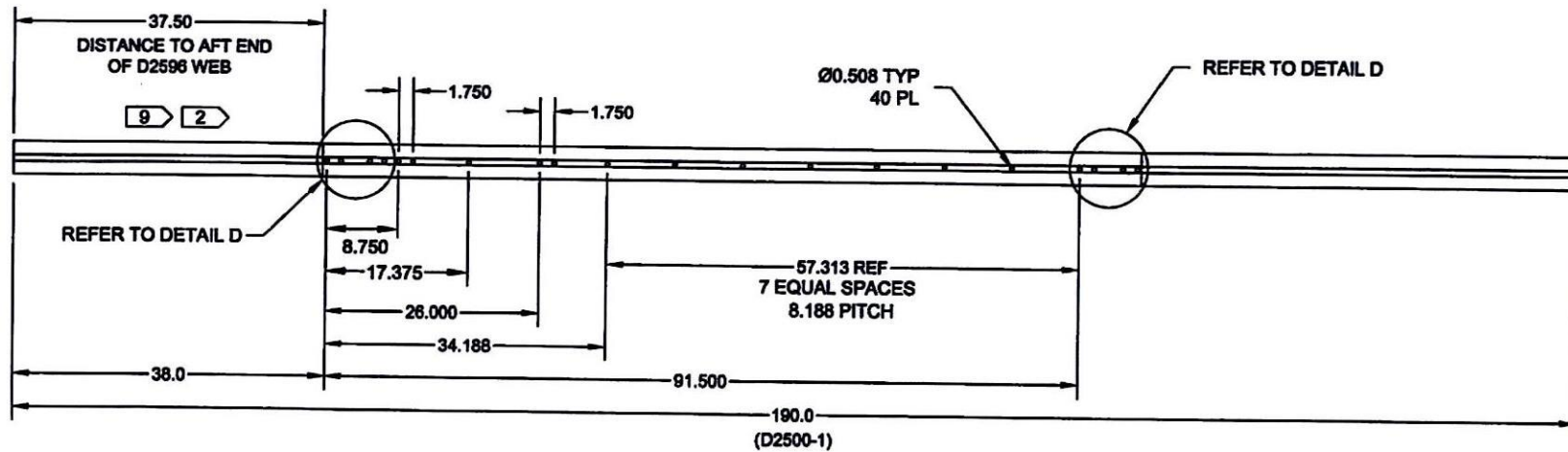
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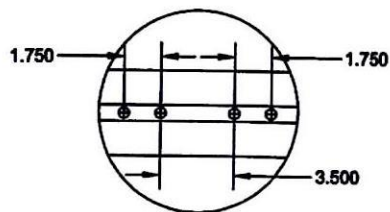
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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D2580-101 TUBE



DETAIL D
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